

4/606



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM632V3023122-1
Job Sheet 181064



25
75

Part No: RBEM632V3023122-1

Job Qty: 6 ea

Part Name: Base



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 7/20/18

Job Tracking No:

Due Date: 7/30/18

Created By: Logan David

Type: SOLD

Description:

Note: RBEM632V3023122 rev.1 IPP REV:A 18.07.18 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/30/18	7/30/18	0.00	0.00	Start Up Machining-4		JB 18-09-09
140	CNC Lathe	6 pcs	7/30/18	7/30/18	0.50	0.50	MORI SL-154		JB 18-09-09
150	QC	6 pcs	7/30/18	7/30/18	0.00	0.00	QC2 Machining-5		JB 18-09-09
160	QC	6 pcs	7/30/18	7/30/18	0.00	0.00	QC8 Machining-5		JB 18-09-10
170	Powdercoat	6 pcs	7/30/18	7/30/18	0.00	0.75	Powdercoat13		SEP 11 2018
180	QC	6 pcs	7/30/18	7/30/18	0.00	0.00	QC3		SEP 22 2018
190	Packaging	6 pcs	7/30/18	7/30/18	0.00	0.00	Packaging3-2	EA	SEP 22 2018
200	QC21-SA	6 Ea	7/30/18	7/30/18	0.00	0.00	QC21		9-89 MJS 18-09-24

Part Op 140 - 1-Machine as per folio FC264 FOLIO REV: DWG REV: 2-Debur
 Descriptions: 170 - START TIME: 2:20 OVEN TEMPERATURE: 320° FINISH TIME: 2:55
 190 - IDENTIFY AND STOCK

0858677

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R1.500	1018 Round Bar 1.500	1.6800 ft (.28 ea)	90-Start up Operation	M16210

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018R1.500	2	29	0

Part Specifications



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Plex 7/20/18 8:04 AM dart.logan.david

Container No: S108603



Part: RBEM632V3023122-1

Job No: 181064

Serial No/Batch: S108603

Revision: 1

Inspector:

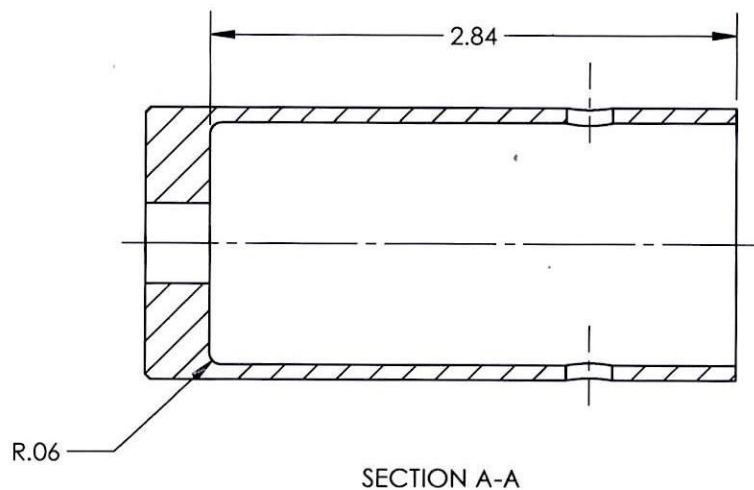
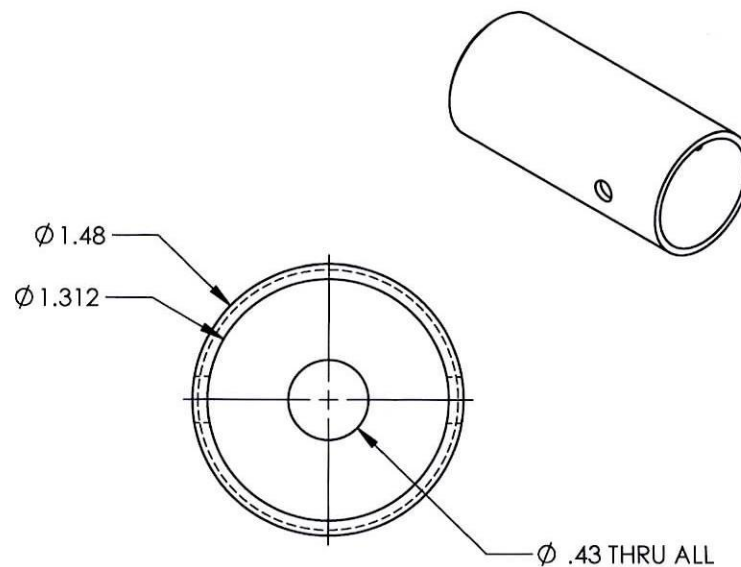
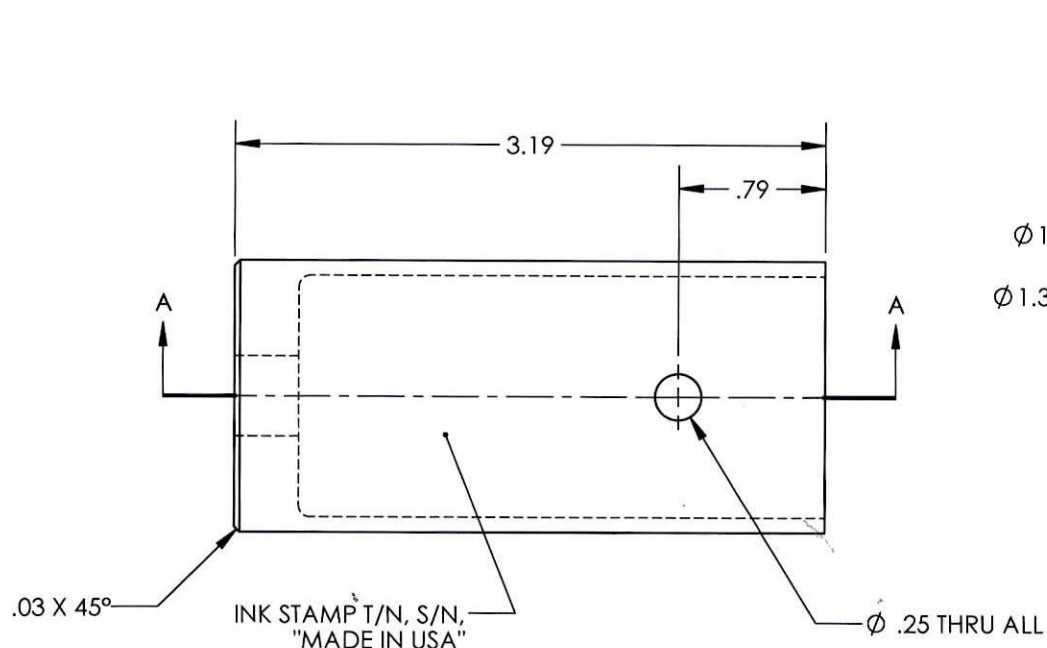
Exp Date:

Instructions:

Date: 09/09/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



(-1)

BASE

DART AEROSPACE	
TITLE LOWER SERVO CONTROL AXLE EXCHANGE	
DWG NO. RBEM632V3023122-1	REV 1
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH POWDER COAT YELLOW	.XX ± .01 ANGLES ± 5°
SPEC FED #13538	.X ± .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 3/24/2016 SHEET 2 OF 3